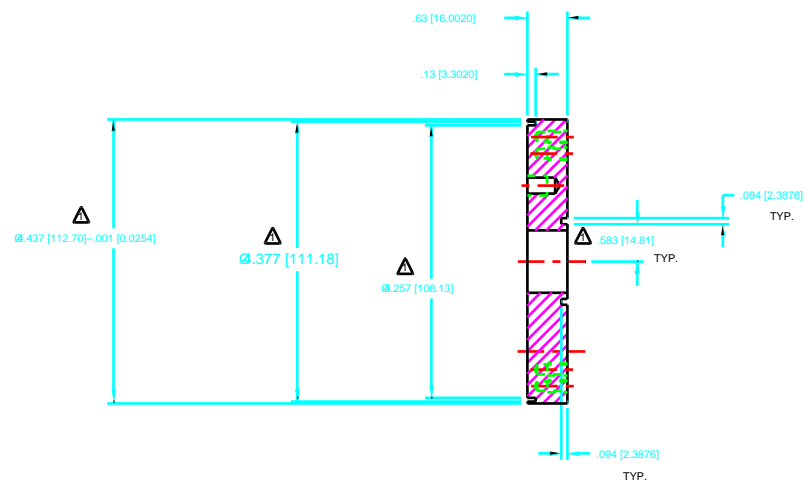
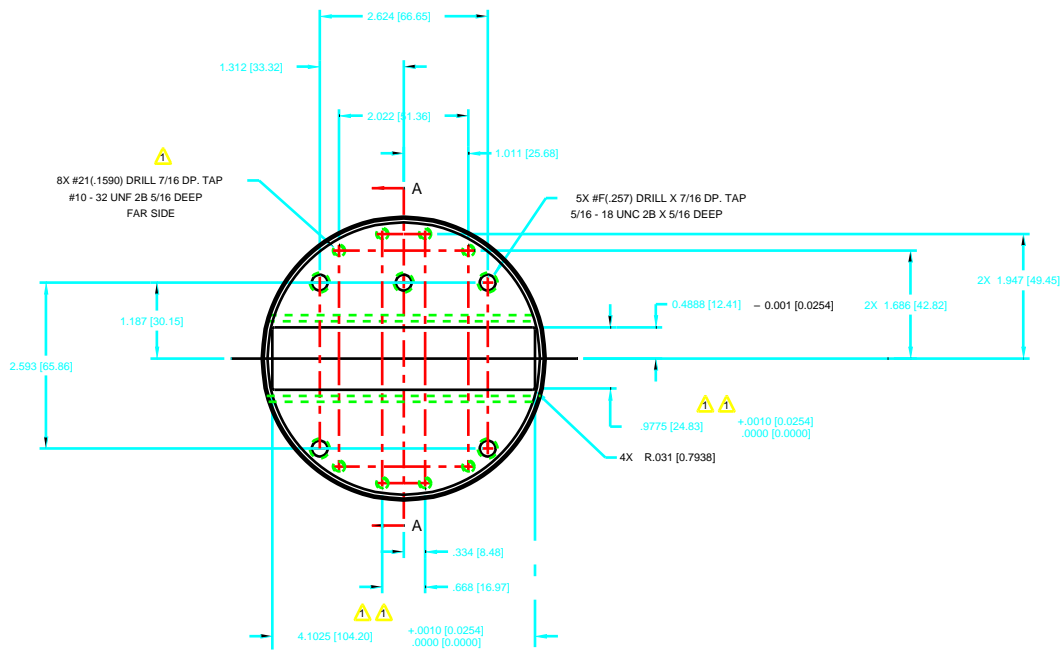


(D)	PLOT SCALE: 1=1	DWG. SCALE: 1	A12517
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SECTION A - A

NOTES:

1. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
2. THIS IS A UHV PART. ELECTROPOLISHING IS NEEDED BEFORE WELDING. PRIOR TO ELECTROPOLISHING, THE PART NEEDS TO GO THROUGH A MULTIPLE STEP CLEANING PROCESS INVOLVING DEGREASING, WASHING AND DRY NITROGEN BLOW DOWN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [ ] ARE MILLIMETERS

1	.583 [14.81] WAS .563 [14.30]	D.S.
1	.257 [108.13] WAS 4.195 [106.55]	D.S.
1	.377 [111.18] WAS .315 [109.60]	D.S.
1	.9775 [24.83] WAS .9375 [23.81]	D.S.
1	4.1025 [104.20] WAS 4.0625 [103.19]	D.S.
1	.437 [112.70] WAS .375 [111.13]	D.S.
1	(8) #10-32 TAPPED HOLES ADDED	D.S.
1	DIMENSIONS WERE .06 ABOVE	D.S.
1	THE CENTER LINE	M.J.M.
BY	CHANGE DESCRIPTION	BY CHD DATE
REVISIONS		

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
<p>UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES TOLERANCES: DECIMALS ANGULAR X .05 .05 XX .02 .02 XXX .005 .005</p> <p>SURFACE ROUGHNESS 125</p> <p>REMOVE ALL BURRS AND BREAK SHARP EDGES (R&amp;M)</p> <p>SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS 491</p> <p>DIMENSIONING &amp; TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5</p> <p>DO NOT SCALE DRAWING</p>				
LOG NUMBER <b>A12517</b>		THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>		
DRAWN BY <b>MUSCIA</b>	DATE <b>8/3/92</b>	CHIEF DESIGN ENGINEER <b>D. SHU</b>	DATE <b>2/3/93</b>	TITLE <b>ADVANCED PHOTON SOURCE P1 1 ST PHOTON SHUTTER ADAPTER &amp; PIVOT PLATE</b>
DESIGNED BY <b>D. SHU</b>	DATE <b>2/3/93</b>	PROJECT MGR. <b>T. M. KUZAY</b>	DATE <b>2/3/93</b>	
DESIGNER <b>MUSCIA</b>		APPROVED/RELEASED		
RESPONSIBLE ENGINEER <b>D. SHU</b>				
MATERIAL <b>304 STAINLESS STEEL</b>				
SCALE <b>1:1</b>		SHEET <b>1 of 1</b>		
DRAWING NUMBER <b>P4102010103-210001-01</b>				